

sped w/o
SB 07/11/13Date: Tuesday, 8/28/2007 3:23:20 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ARM
Job Number	34321-2		
Estimate Number	12973		
P.O. Number	N/A	Part Number	D36461
This Issue	8/28/2007	S.O. No.	N/A
Prsh Rev.	NC	Drawing Number	D3646 REV.A
First Issue	N/A	Project Number	N/A
Previous Run	N/A	Drawing Revision	A
Written By		Material	N/A
Checked & Approved By		Due Date	9/28/2007
Comment	Est Rev. A new issue 07.07.25 EC verified by:JLM	Qty:	10
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
		Comment: Qty.: 2.0790 f(s)/Unit Total : 20.7900 f(s) Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)
	Batch: M106015	SB 07/11/14 ⑨
2.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE
		1-Punch to length as per Dwg D3646 & template DT8958 SB 07/11/14 ⑨
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1
	1-Deburr	G 07/11/14 ⑨
4.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP C 07/11/14 ⑨ counter
5.0	POWDER COATING	POWDER COATING
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 BR 07-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/18	1	Split W/O		07/11/18	9		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/11/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:23:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34321

Part Number: D36461

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Co 7/14/21 6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 266*

P *AS 07/11/21* *(9)*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/22

Job Completion



W 08.11.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

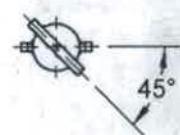
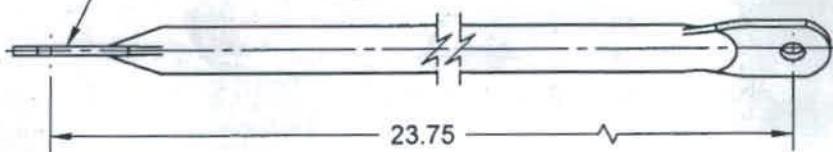
NOTE: Date & initial all entries

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D3646	REV. A	SHEET 1 OF 2
DATE 07.06.06		TITLE ARM	SCALE 1:2	
REV A	DATE 07.06.06	DESCRIPTION NEW ISSUE		

RELEASED07.07.11 *[Signature]*

PUNCH BOTH ENDS PER
DART SPEC CONTROL
DRAWING D2727

**D3646-1 ARM****NOTES:**

- 1) MAKE PER TEMPLATE DT8958
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 0054.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *34321*

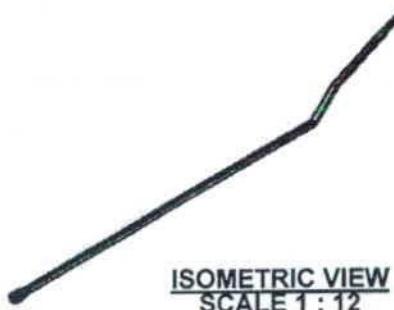
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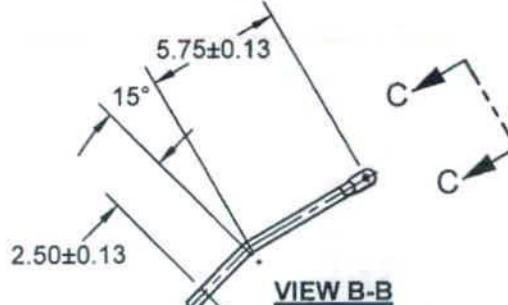


DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3646	REV. A SHEET 2 OF 2
DATE 07.06.06	TITLE ARM	SCALE 1:8	



ISOMETRIC VIEW
SCALE 1:12

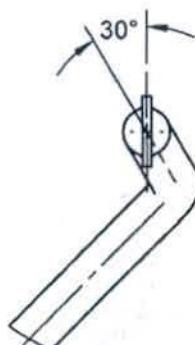
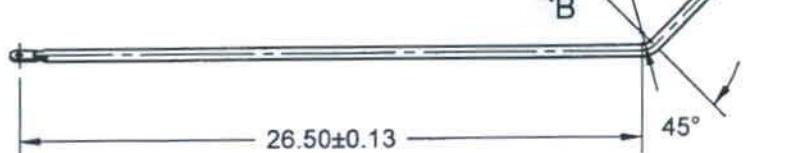


VIEW B-B

PUNCH BOTH ENDS PER
DART SPEC CONTROL
DRAWING D2727



DETAIL A
SCALE 1:2



VIEW C-C
SCALE 1:2

D3646-3 ARM

NOTES:

- 1) MAKE PER TEMPLATE DT8959
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.500W.035)
- 3) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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